

5/20

127mm

DART AEROSPACE LTD		Work Order:	23045
Description: Short Pin Bracket		Part Number:	D3330-13 11
Dwg: D3330 Rev. A PAGE 9 RF 05.01.17		Qty:	14 20
			Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	AD	05.04.15	20
2	MV	Cut blanks: 2.500" x 1.000" x 5.00" long (+/-0.030) Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel (M1010-B2.500x01.000) Identify for D3330-13 11 Batch: M16634	150 SD	05.05.04	15
3	MV	Machine as per Folio FA480 and Dwg D3330 Identify as D3330-13 11	SD	05.05.04	15
4	QC2	Inspect parts as they come off the CNC machine	SD	05.05.04	15
5	QC8	Second check	EL	05.05.04	15
6	MV	Deburr	SD	05.05.04	15
7	QC5	Inspect work to Step 6	2	05.05.05	14
8	ST	Identify and Stock	CPL	05.05.05	14
9	AC	Cost / part: 22.33	54C	05.05.06	14
10	DC	Close W/O 19.60 Inspect Level 21	AD	05.05.11	14


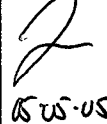
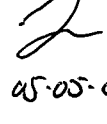
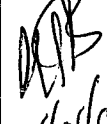
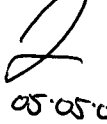
No Mat.


P.T.O

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

RELEASED
05.01.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-05-05	3	Scrap bottom hole drilled And bored on the wrong side.		Scrap & destroy. No mat'l to replace. See NCR 874	 05-05-05	 05-05-05	 05/05/05	 05-05-05

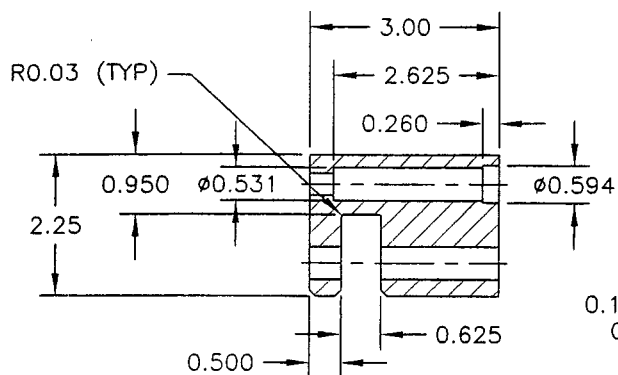
Part No: D3330-11 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05-05-11

NOTE: Date & initial all entries

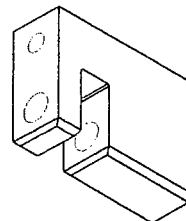
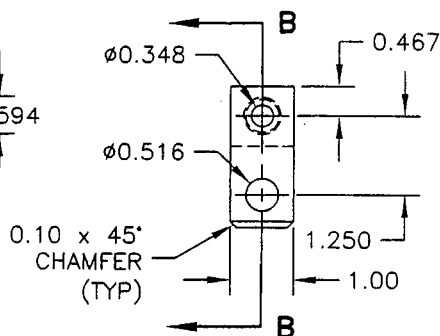
QA: N/C Closed: _____ Date: _____

DART
PRELIMINARY ISSUE

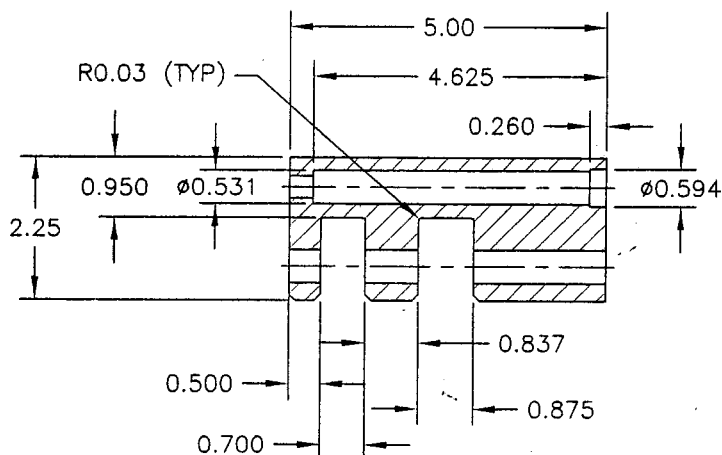
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D3330	REV. B SHEET 9 OF 9
DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:3



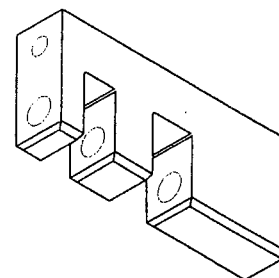
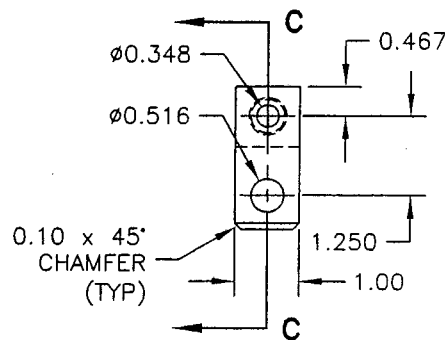
SECTION B-B



D3330-13 SHORT PIN BRACKET



SECTION C-C



D3330-11 LONG PIN BRACKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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ENGINEERING

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WORK ORDER

NO. 23045

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2005
02:25 pm

Work Order No : 0023045
Project Name : D3330-13
Project For : WK520
Work Order Type : Main
Main WO Number :
House Part Number : D3330-13
Description : Short Pin Bracket
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 04-12-05
Est Finish Date : 05-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 23048
Description:		Part Number: D3330-11
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	±.030	5.025	/			
4.625	±.010	4.632	/			
.260	--	.258	/			
Ø.594	+0.005 -0.000	Ø.594	/			
.875	±.010	.871	/			
.837	--	.842	/			
.700	--	.698	/			
.500	--	.504	/			
2.25	±.030	2.250	/			
.950	±.010	.948	/			
Ø.531	+0.005 -0.000	Ø.532	/			
Ø.348	--	Ø.349	/			
Ø.516	--	.517	/			
.467	±.010	.469	/			
1.250	--	1.249	/			
1.00	±.030	.999	/			
10 X 45°		Ø9 X 45°	/			

Measured by: SD	Audited by: [Signature]	Prototype Approval: N/A
Date: 05.05.04	Date: 05.05.04	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	